

**Work Order ID 56068**

Page 1

February 9, 2010 1:28:06 PM

Item ID: D3942-1

Accept



Setup Start



Revision ID:

Item Name: Angle

Stop



Start Date: 2/09/10 Start Qty: 20.00



Cust Item ID:

Required Date: 2/15/10 Req'd Qty: 20.00



Customer:

Reference:

Approvals: Process Plan:

P1

Date: 10-2-09 Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

100



Waterjet

FLOW CNC Waterjet

304.050

Memo

0.00

RB 10-2-16

1-Cut as per Dwg D3942-1

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

=7 Deburr m-f 10/02/17

30

110



QC

QC2- Inspect parts off machine FAI/FAIB

0.00

RB 10-2-16

P10 →

Quality Control

Memo

0.00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Work Order ID 56068**

Page 2

February 9, 2010 1:28:06 PM

Item ID: D3942-1

Accept



Setup Start



Revision ID:

Item Name: Angle

Stop



Start Date: 2/09/10

Start Qty: 20.00



Cust Item ID:

Required Date: 2/15/10

Req'd Qty: 20.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120



QC

Quality Control

QC8- Inspect parts - second check

0.00

S100217

0.00

counted  
XZB

f

P10 →

130



Brake NC

Brake NC

Memo

0.00

SB 10/02/22

0.00

29 0

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

S100218

0.00

counted  
XZB

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3942-1 PAR #:  Fault Category: Small Flap/walk Set NCR: Yes No DQA: J Date: 10/03/02  
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: J Date: 10/03/02

		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10/02/22	#10	Qty +1 part scrap. hole location are off. RE Part mixes during <del>water</del> water setting R.C. process	J 10/02/22	-Scrap + Destroy no replace Qty +1	SAD 10-02-22	S 10/02/22	J 10/02/22	J 10/02/22

NOTE: Date & initial all entries

**Work Order ID 56068**

Page 3

February 9, 2010 1:28:06 PM

Item ID: D3942-1

Accept



Setup Start



Revision ID:

Item Name: Angle

Stop



Start Date: 2/09/10 Start Qty: 20.00



Cust Item ID:

Required Date: 2/15/10 Req'd Qty: 20.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

150



Identify as per dwg &amp; Stock Location:

0.00

Packaging

Memo

0.00

Packaging

160



QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

February 9, 2010 1:28:10 PM

Page 1

Work Order ID: 56068



Parent Item: D3942-1



Parent Item Name: Angle

Start Date: 2/09/10

Required Date: 2/15/10

Comments:

Start Qty: 20.00

Required Qty: 20.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304S18GA		Purchased		No		100	sf	225.4922	0.3158			

304/316 .050 Sheet

Warehouse Loc Qty Loc Code

Location

Main Warehouse

MAT	225.4921632
108156	0.98526316
111743	23.7174
112885	72.7895
113062	128
112178	

KB 10-2-16

30

112178

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	56068
Description: Angle	Part Number:	D3942-1
Inspection Dwg: D3942	Rev: A	Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

## X First Article      Prototype

Measured by:	BS	Audited by:	S	Prototype Approval:	N/A
Date:	10-2-16	Date:	10/02/17	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	09.06.22	New Issue	KJ	

~~STOP COPY~~  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDERS  
NO. 56000

3810-2-09

10 of 10

A technical drawing of a rectangular component. The top edge features two circular features, each with a crosshair center. A vertical dimension line on the right side indicates a height of 2.30. The bottom edge is marked with a dashed line and a horizontal dimension line, but no specific value is provided.

**D3942-1 ANGLE**  
MADE FROM D3942-1F

NOTES:  
1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR AMS 5524  
18 GAUGE (0.050 THICK)  
REF DART SPEC M304S18GA

2) FINISH: NONE

### 3) TOLERANCES: PER DART QSI 018 UNLESS

4) UNITS: INCHES

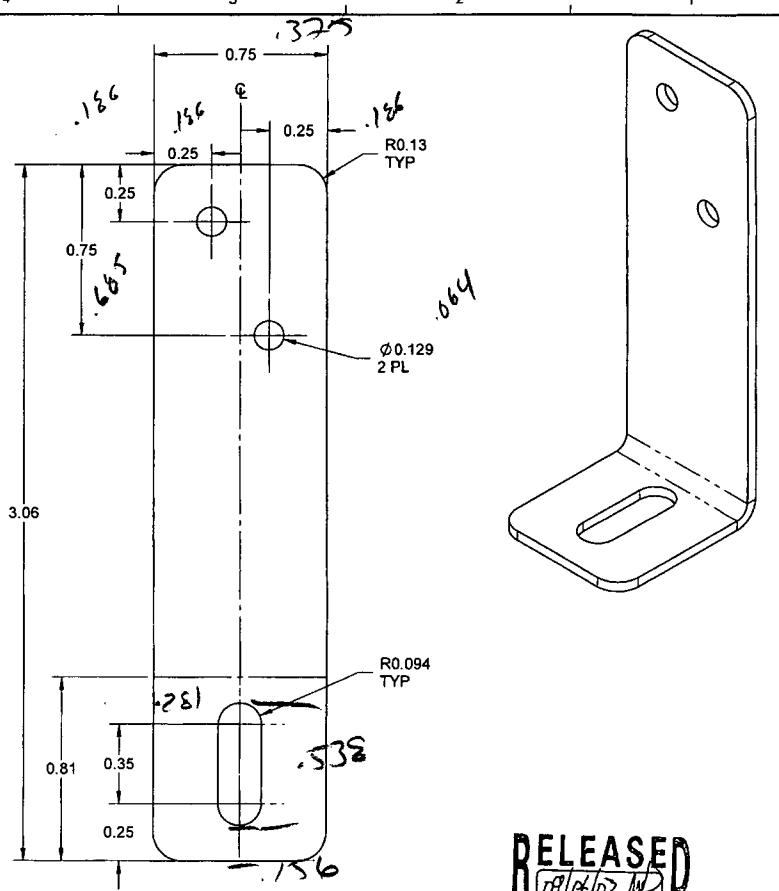
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

**6) IDENTIFICATION: IDENTIFY WITH DART P/N "D"**

7) WEIGHT: 0.03 lbs

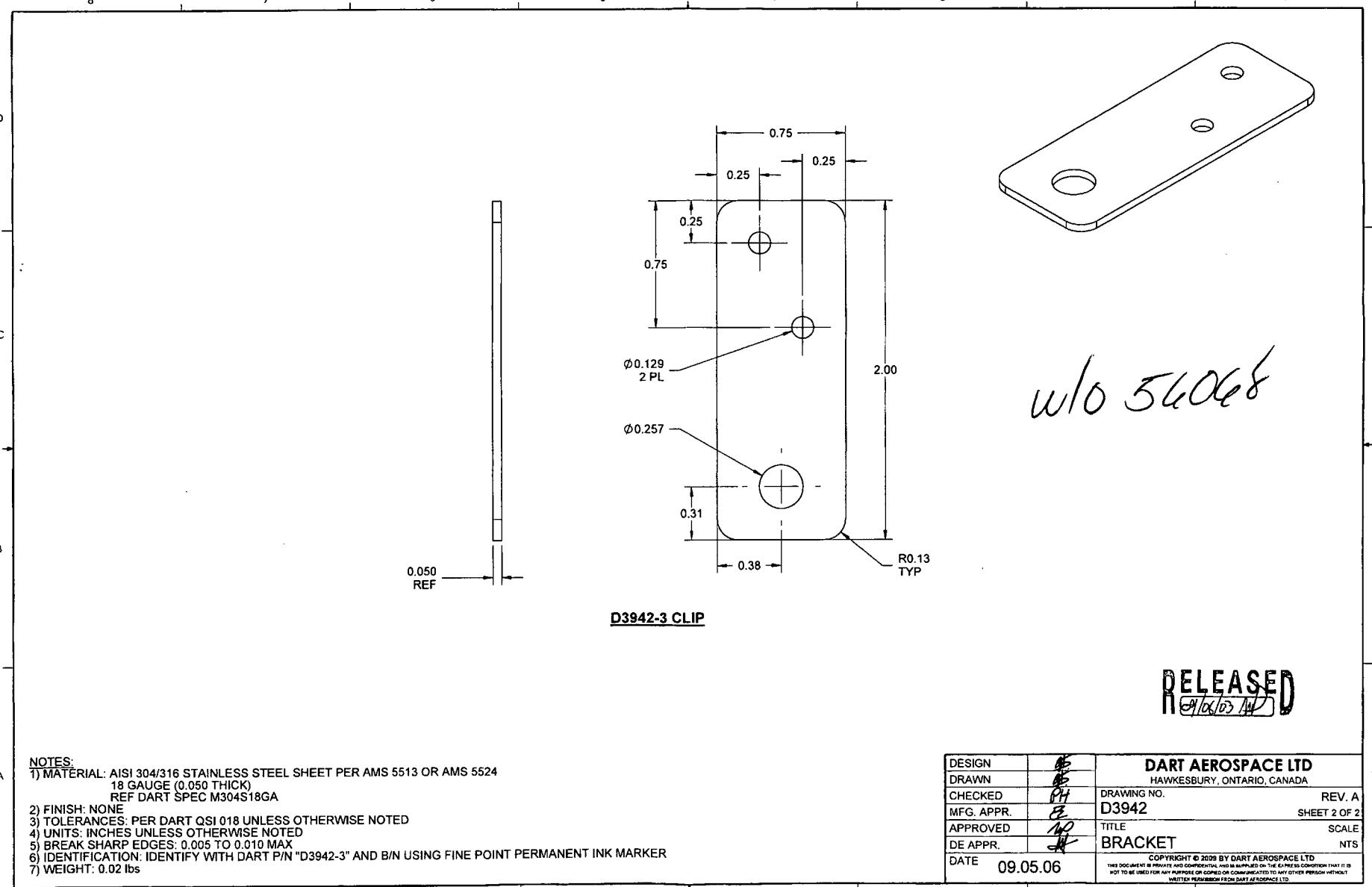
7) WEIGHT: 11.00 lbs

8



RELEASED  
09/06/03 M

A	NEW ISSUE			09.05.06
REV.	DESCRIPTION		BY	DATE
DESIGN	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA			
DRAWN				
CHECKED	PT	DRAWING NO.	REV. 1	
MFG. APPR.	PZ	D3942	SHEET 1 OF	
APPROVED	10	TITLE	SCAL	
DE APPR.	<u>S</u>	BRACKET	NT	
DATE	09.05.06	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT		



DESIGN	<i>AB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	<i>AB</i>	DRAWING NO. <b>D3942</b> REV. A
CHECKED	<i>PH</i>	SHEET 2 OF 2
MFG. APPR.	<i>EE</i>	
APPROVED	<i>AB</i>	TITLE <b>BRACKET</b>
DE APPR.	<i>AB</i>	SCALE NTS
DATE	09.05.06	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OTHER THAN THE CONSTRUCTION OF THE PARTS BY THE OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD